

Date: Monday, 29/09/2008 11:37:04 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350 SKIDTUBE ASSEMBLY LH
Job Number : 42336	
Estimate Number : 10262	
P.O. Number :	Part Number : D350636011
This Issue : 29/09/2008 S.O. No. :	Drawing Number : D2750 REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : F
Previous Run : 42335	Material :
Written By :	Due Date : 08/10/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JLD 08.9.29</u>	
Comment :	
Est Rev:I 02.09.25 Rearranged procedure steps KJ	
Est Rev:J 06-03-23 As per Rev D JLM	
Est Rev:K 06-07.13 As per dsi9343 EC	
Est Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM	
Verified By:EC	
Est Rev:M 08-04-22 update steps 4, 13 DD verified by:EC	
Est Rev:N 08-09-23 revF as per dwg DD verified by:ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-011 CHG 004

2.0	D26003BENT	Extrusion Bent
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

B41122

① 14 8-9-30

3.0	D2744	Cap
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch:

B32242

BE 8-9-30

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.

① 14 8-9-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4-Drill pilot holes for Detail G using DT8330

5-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 5 holes per side) as per dwg D2750 .Open up holes for ground handling and detail E to 0.500" (8 holes per side)

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108

****Make sure that wearplate holes are on bottom of tube***** Open 4 aft wearplate holes to 0.250". Open remaining wearplate holes to 0.297"

7-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod *m/09213 BE 8-9-30*

10-Grind welds flush as per Dwg D2750 *BE 8-9-30*

12- Scribe batch# inside per dwg D2750 *BE 8-9-30*

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/09/30 (70)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/30 (70)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FT 08-09-30

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/09/30 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Web
Batch: _____

10.0

D34901

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Crossbolt spacer
Batch: _____

11.0

D34903

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Crossbolt spacer
Batch: _____

12.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Crossbolt Spacer
Batch: _____

13.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail E and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, E, ground handling and float holes per dwg D2750 (welding instructions on sheet 4)



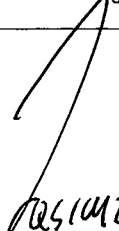

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

PCO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-636-011 PAR #: _____ Fault Category: Prod / Skid tube NCR: Yes No DQA: D Date: 08/10/03
 Resolution: _____ Disposition: _____ QA: N/C Closed: D Date: 08/10/03

NCR: 42336		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-01 08-09-01	13-0	Holes on 1 side of the tubes were opened up too large. 0.45" instead of 0.625". R.C: Employee grabbed the incorrect tool.		- Scrap; destroy No replace. - Remind employee to verify all tools prior to use.	JS 08-10-01			

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Job Number: 42336

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description:

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: _____

exp. date: _____

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 4)

A/R Aluminum Rod

batch: _____

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section P-P (total of 4 places per side) as per dwg D2750

11-Deburr holes

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI/005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

Scrap

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 42336

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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19.0	ALS41032225	Insert
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Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Insert

Batch: _____

20.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Install inserts as per Dwg D2750

21.0	D2745	Bushing
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: _____

22.0	D37911	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: _____

23.0	D37931	Wearshoe
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

Batch: _____

24.0	D37933	Wearshoe
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

Batch: _____

25.0	D37941	Gasket
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: _____

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 42336

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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26.0

D37943

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: _____

27.0

D353525

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: _____

28.0

D353625

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: _____

29.0

D35371

Wearpad



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

WEARPAD

Batch: _____

30.0

D36311

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Batch: _____

31.0

D3488041

Blade Fitting Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: _____

32.0

D3492041

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: _____

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 42336

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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33.0	D3492043	Plug Assembly
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
PLUG ASSEMBLY
Batch: _____

34.0	AN3C5A	Bolt
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Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)
Bolt
Batch: _____

35.0	AN3C6A	BOLT
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
Batch: _____

36.0	AN6C44A	BOLT
------	---------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
BOLT
Batch: _____

37.0	AN8C35A	BOLT
------	---------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BOLT
Batch: _____

38.0	AN960C10L	washer
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Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)
washer
Batch: _____

39.0	AN960C816L	WASHER
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WASHER
Batch: _____

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 42336

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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40.0	MS210436	NUT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: _____

41.0	MS21083C8	NUT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: _____

42.0	NAS1515H3L	WASHER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Batch: _____

43.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: _____

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: _____

EXP DATE: _____

4-Coat all exposed fasteners with "LPS Procyon" batch: _____

44.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 42336

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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45.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Packing Kit

46.0	D2741	Blade, 350 Skidtube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Blade
Batch: _____

47.0	AN8C21A	BOLT
------	---------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: _____

48.0	AN960C816L	WASHER
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
Batch: _____

49.0	NAS1515H8L	WASHER
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
WASHER
Batch: _____

50.0	MS21083C8	NUT
------	-----------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Nut
Batch: _____

51.0	D34931	Washer
------	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
WASHER
Batch: _____

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 42336

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

52.0

D35321

Spacer



Comment: Qty.: 2.0000 (s)/Unit Total: 2.0000 (s)
batch: _____

53.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

54.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Package as per PPP D350-636-011

55.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 0810-01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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62 09 22 11

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	08.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	08.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.04
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
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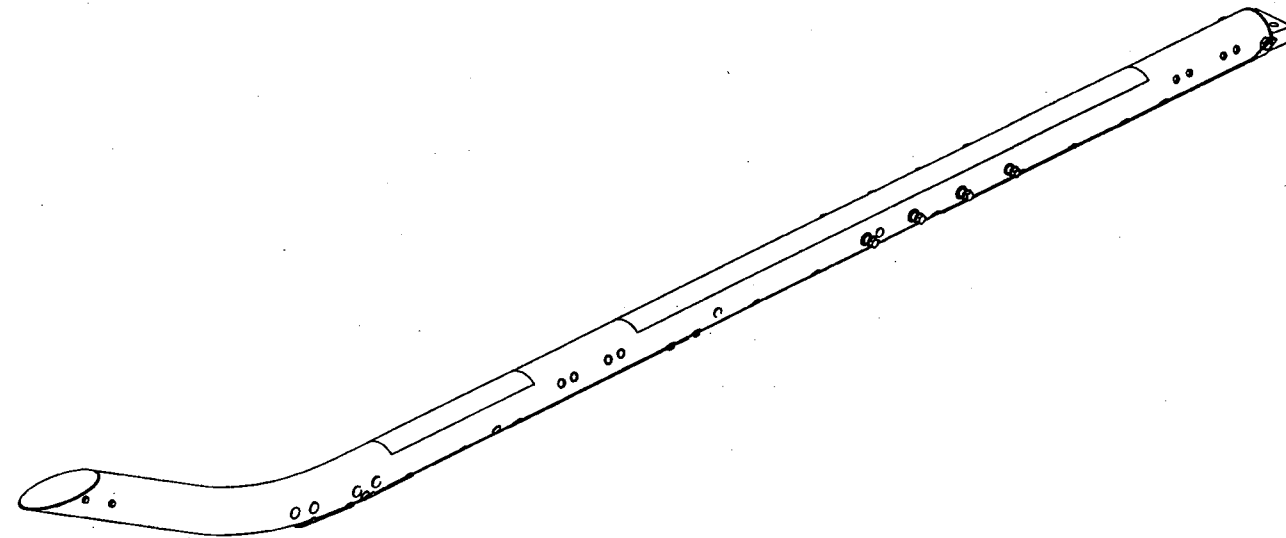
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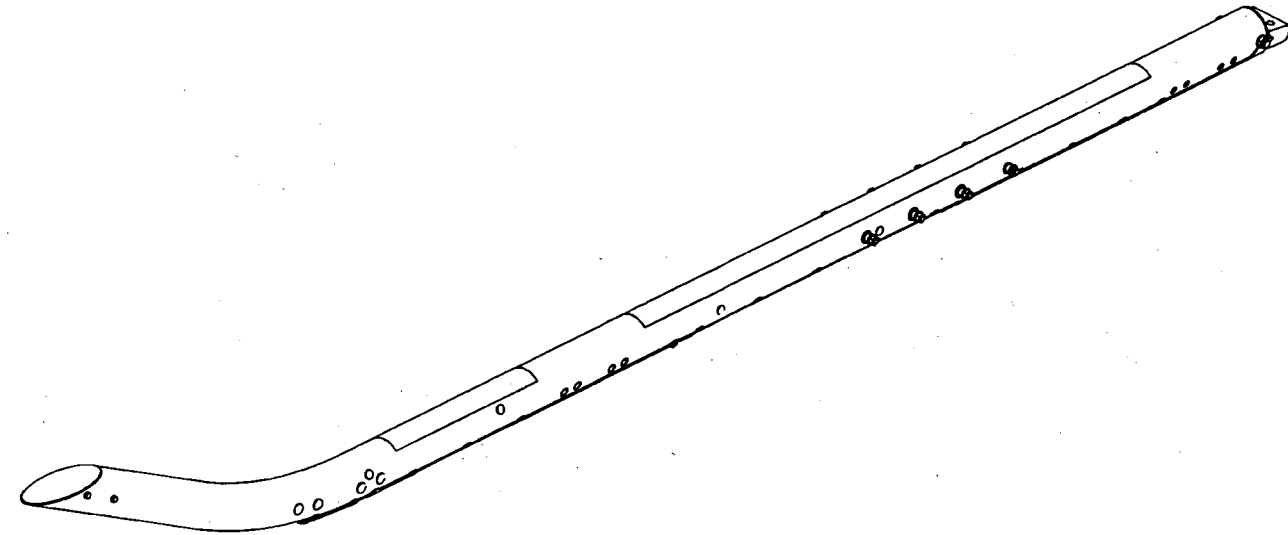
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B

A



D2750-041 350 SKIDTUBE ASSEMBLY, LH

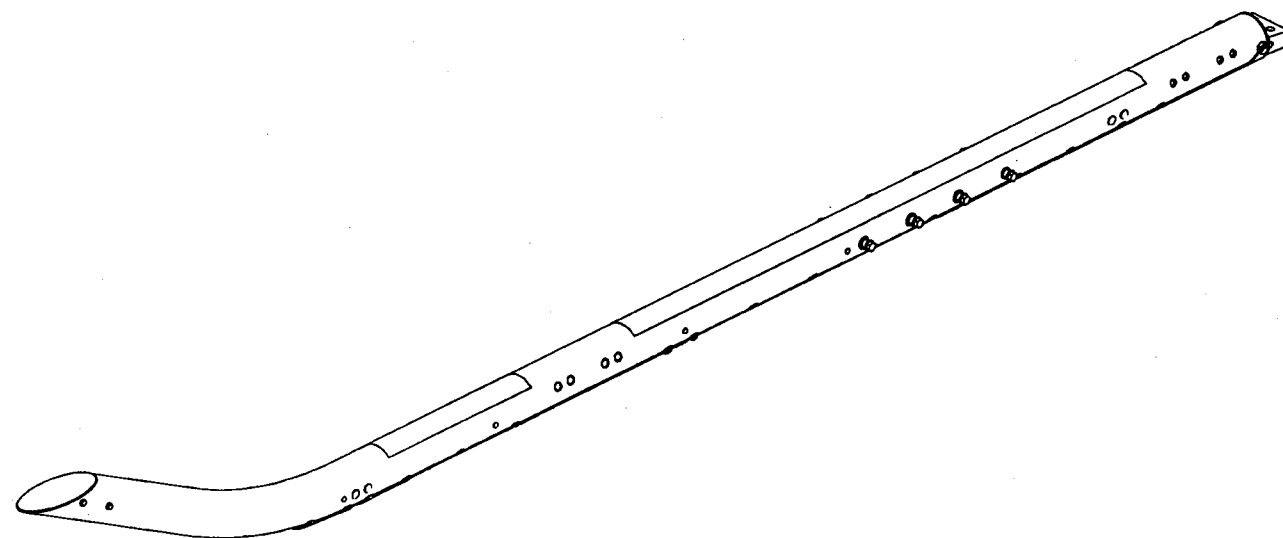


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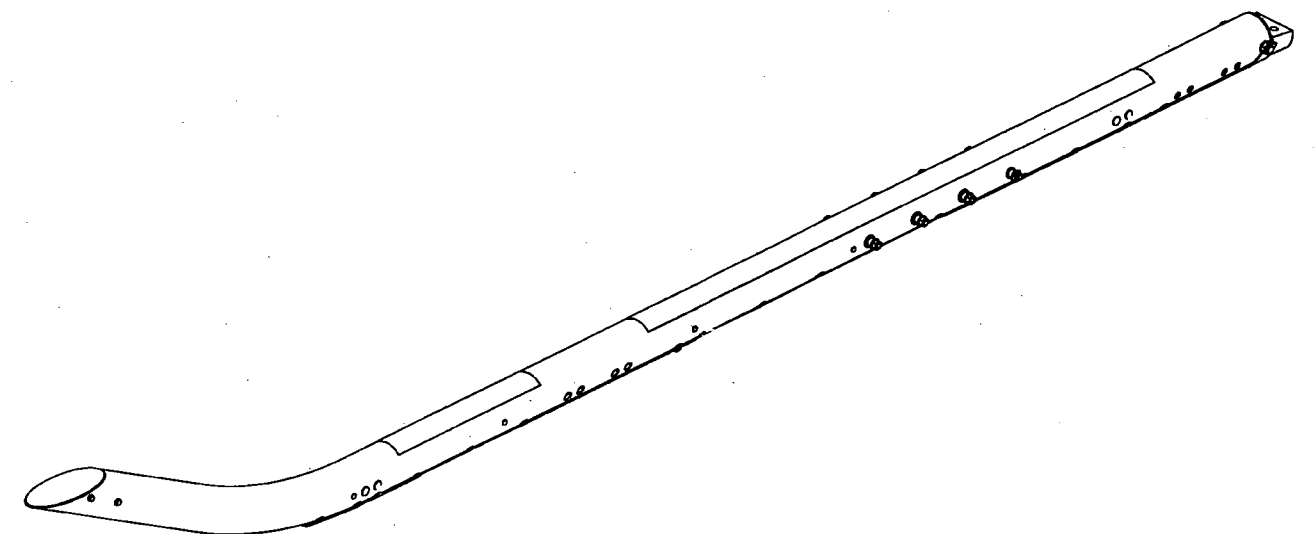
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D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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8 7 6 5 4 3 2 1

D

C

B

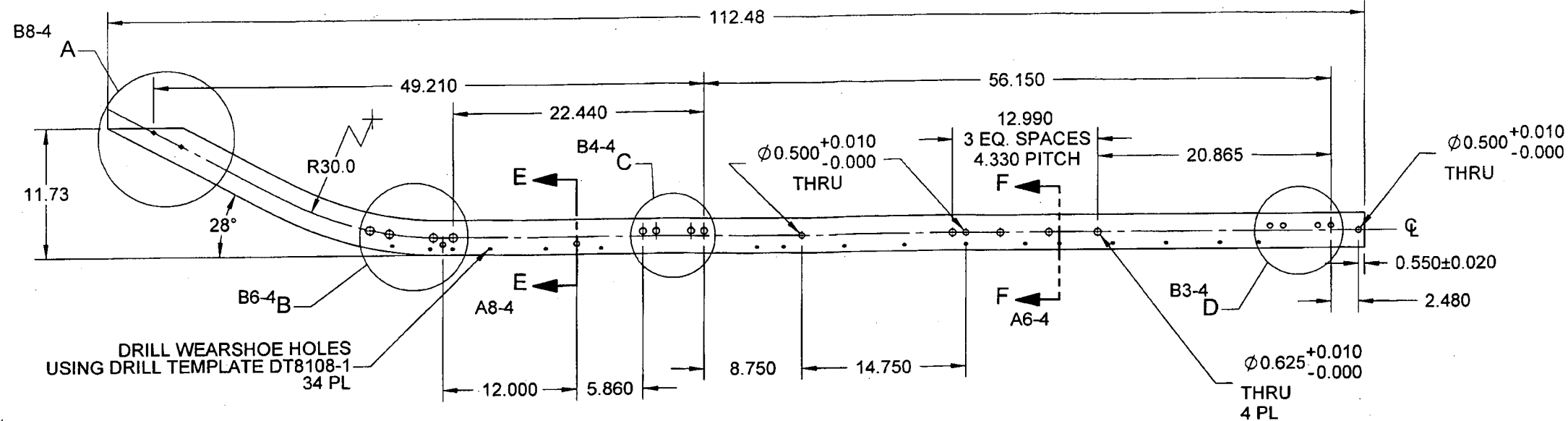
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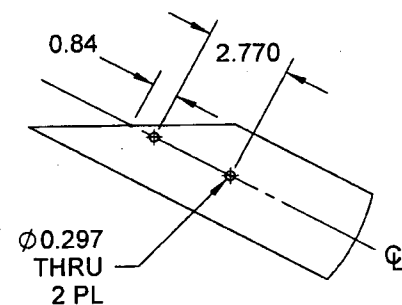
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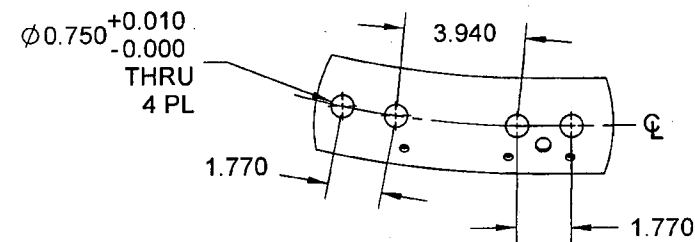
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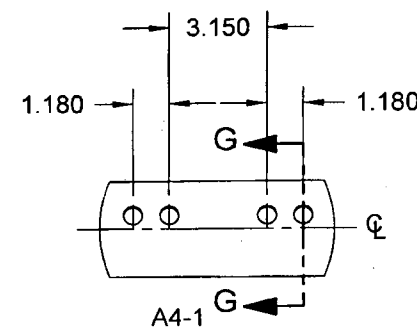
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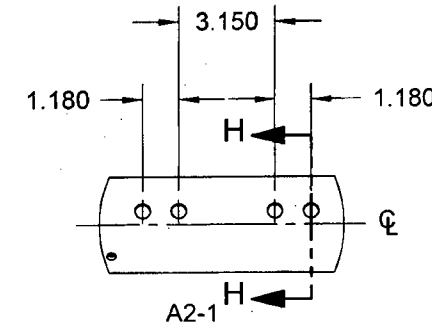
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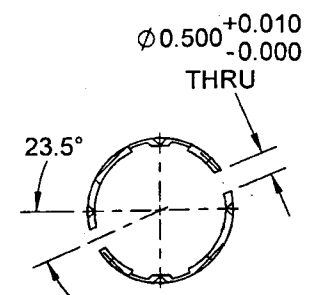
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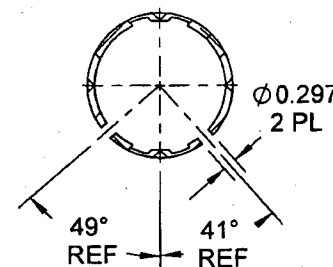
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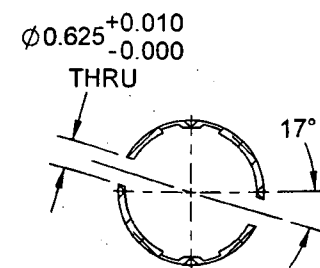
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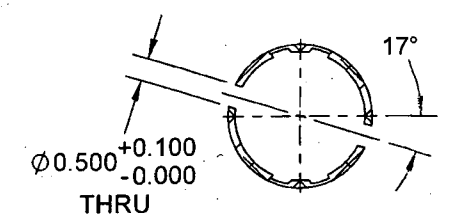
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

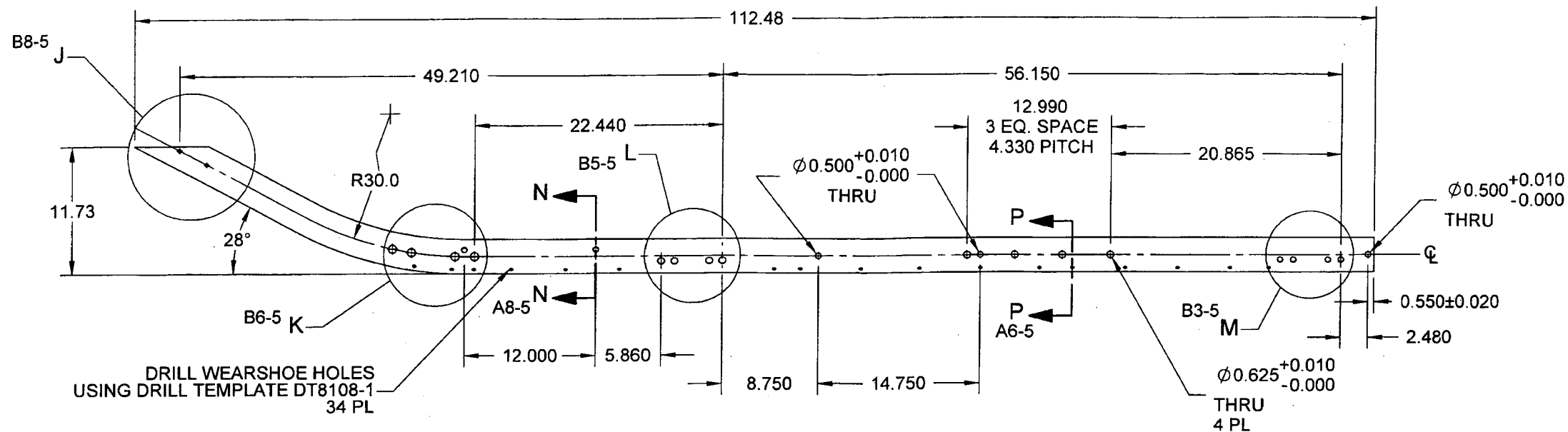


SECTION H-H
SCALE 3X, 4 PL

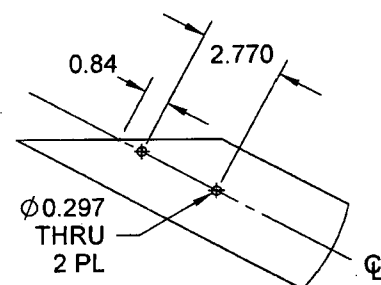
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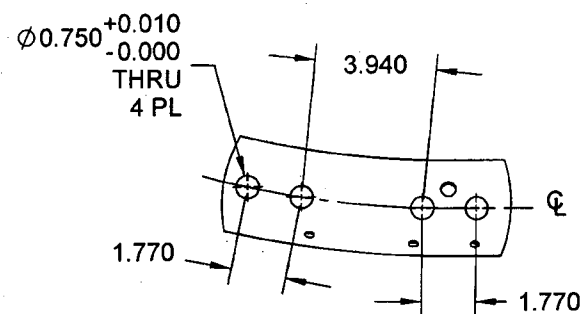
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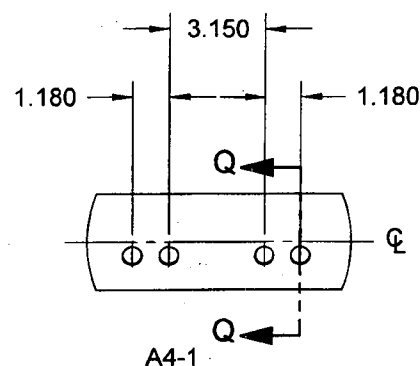
D2750-2 RH SKIDTUBE



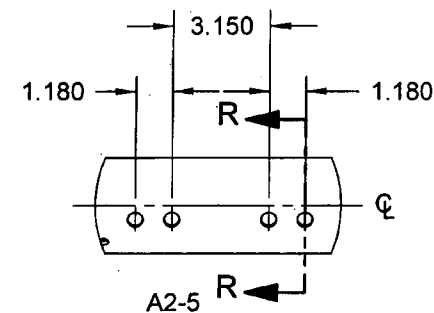
DETAIL J
SCALE 2X



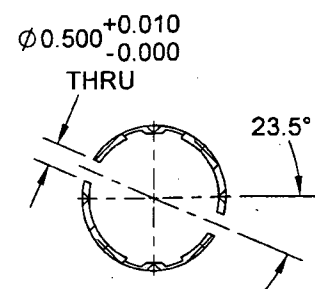
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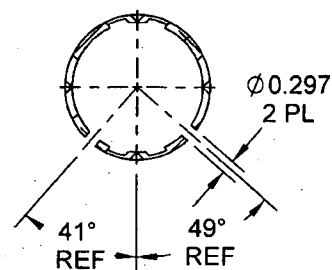
DETAIL L
SCALE 2X



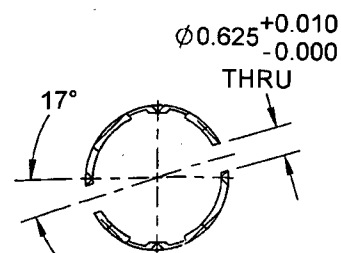
DETAIL M
SCALE 2X



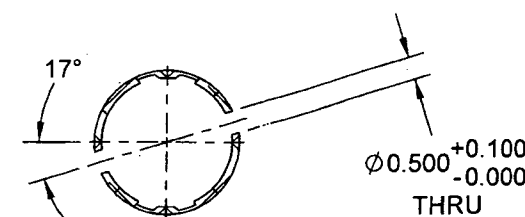
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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8 7 6 5 4 3 2 1

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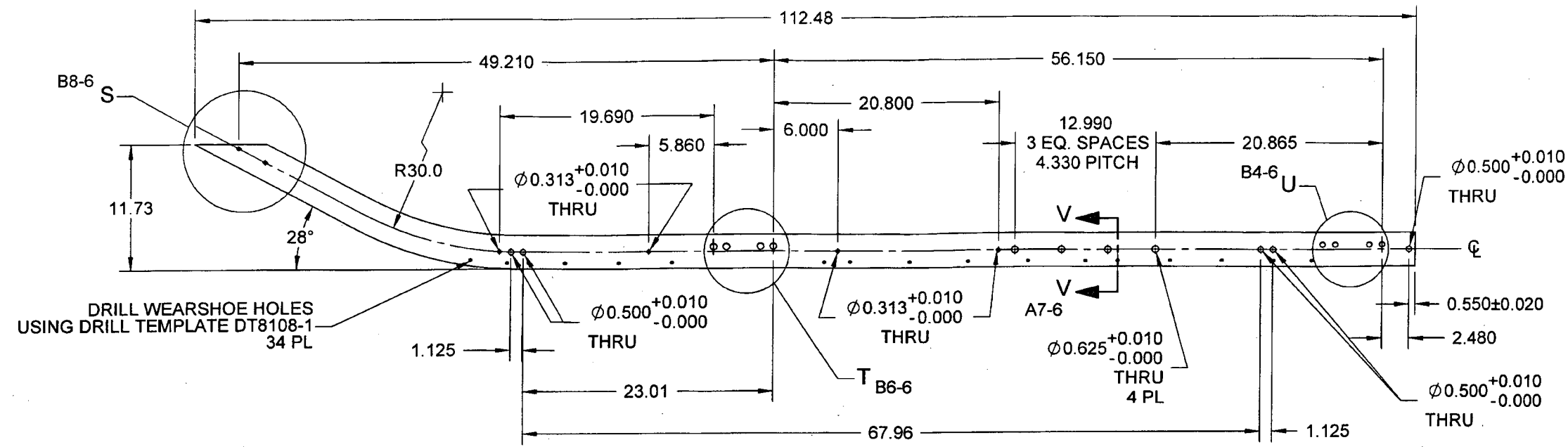
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B

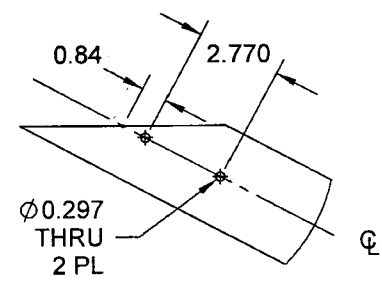
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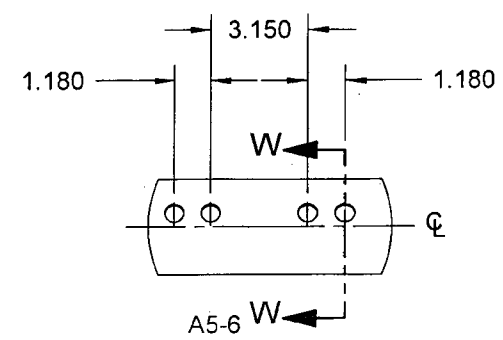
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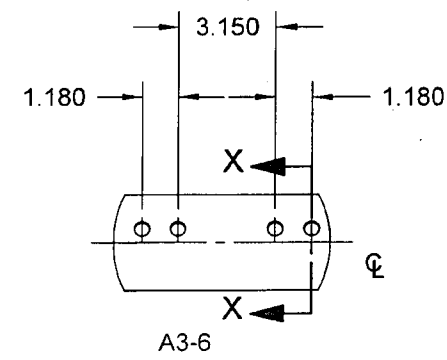
D2750-3 LH SKIDTUBE



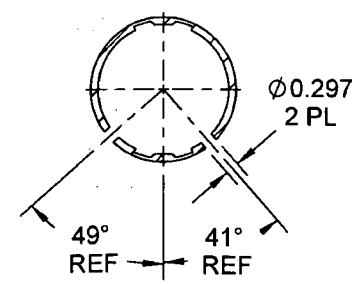
DETAIL S D8-6
SCALE 2X



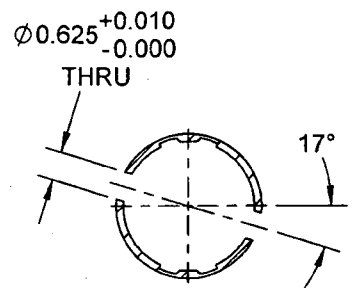
DETAIL T C5-6
SCALE 2X



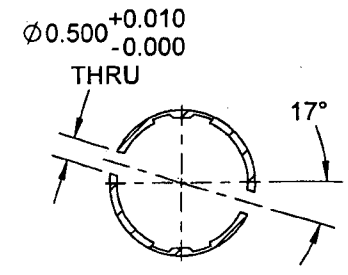
DETAIL U D3-6
SCALE 2X



SECTION V-V C4-6
SCALE 3X, 17 PL



SECTION W-W B6-6
SCALE 3X, 4 PL



SECTION X-X B4-6
SCALE 3X, 4 PL

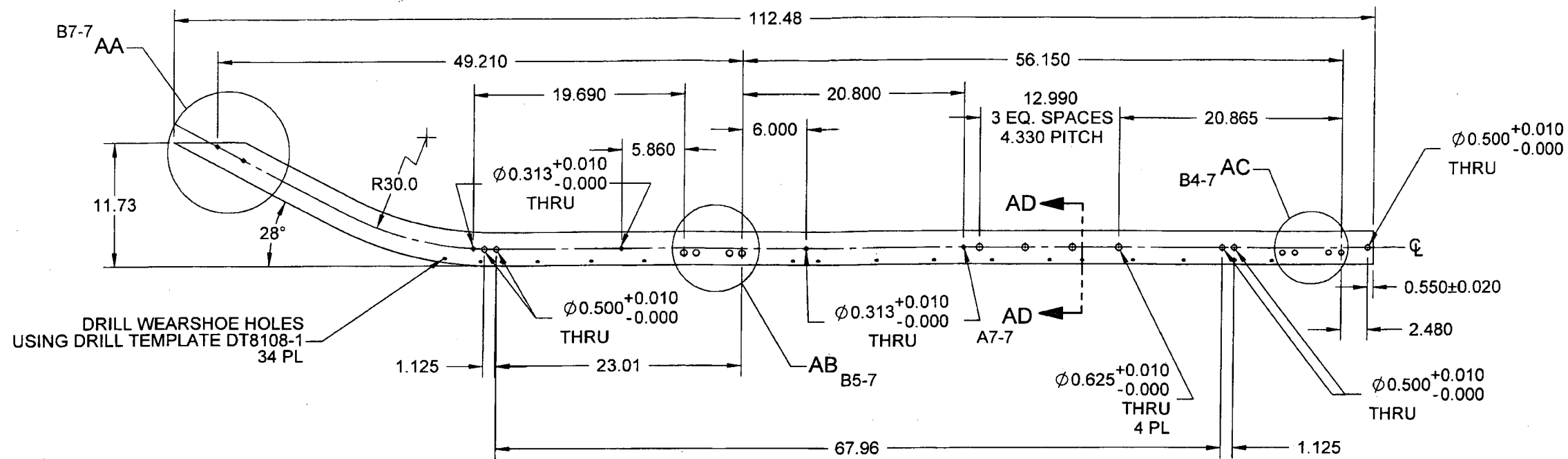
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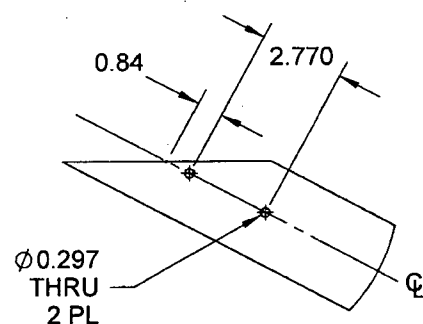
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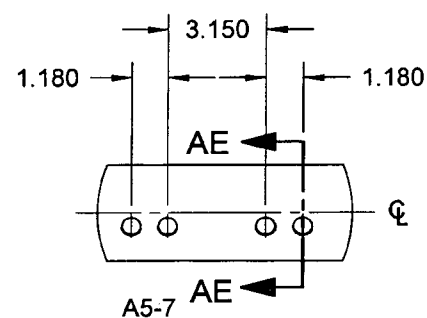
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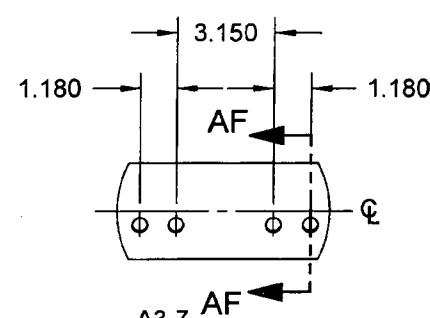
D2750-4 RH SKIDTUBE



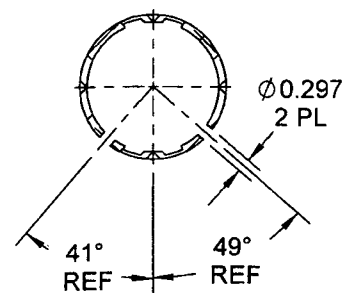
DETAIL AA
D7-7
SCALE 2X



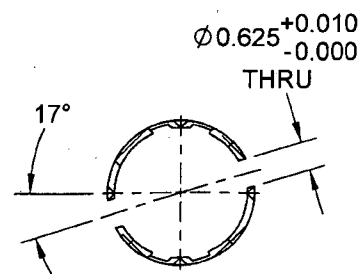
DETAIL AB
C4-7
SCALE 2X



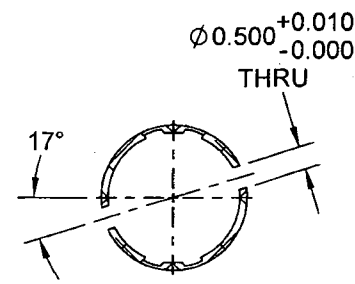
DETAIL AC
D3-7
SCALE 2X



SECTION AD-AD
D3-7
SCALE 3X, 17 PL



SECTION AE-AE
B6-7
SCALE 3X, 4 PL



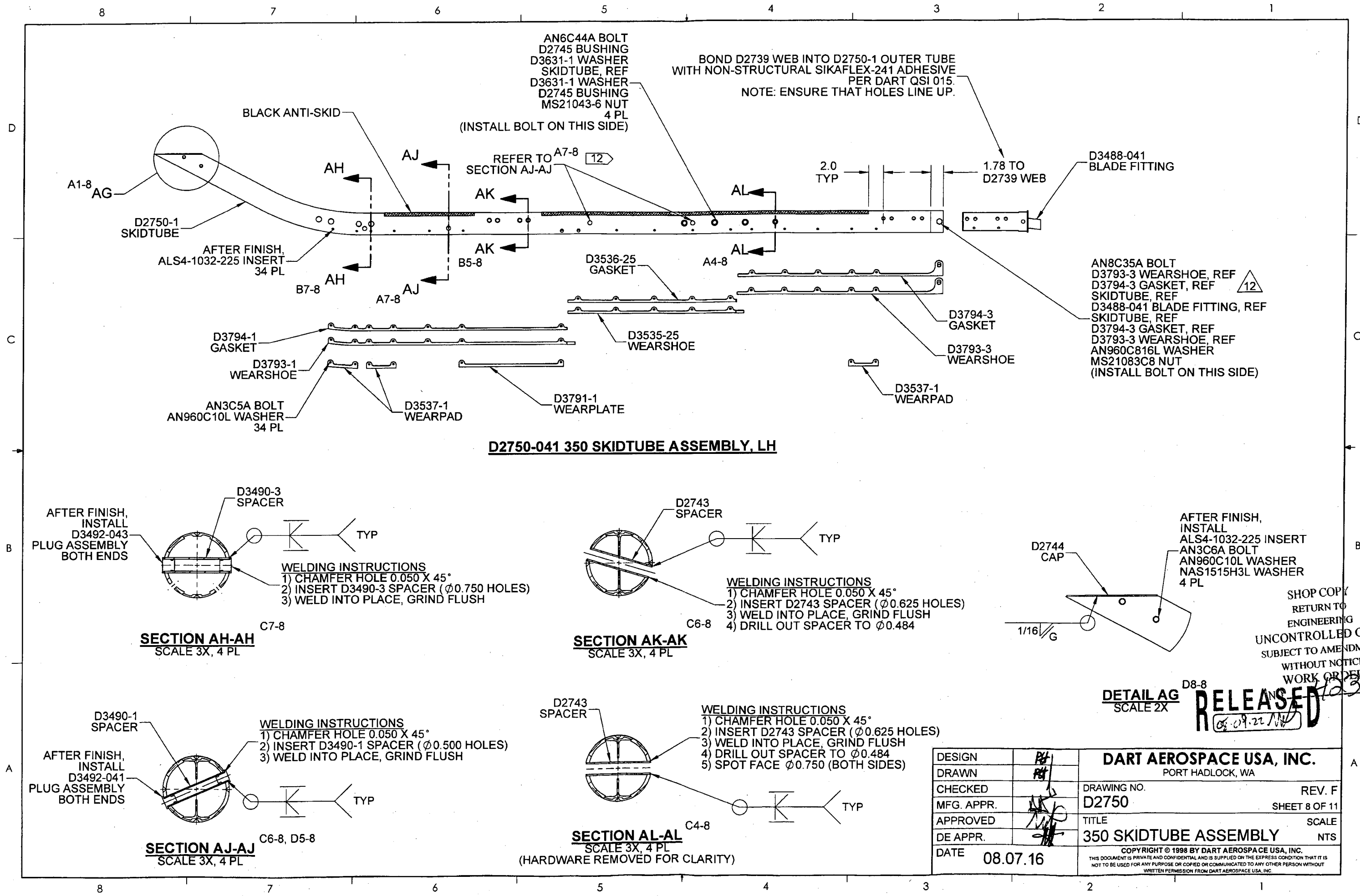
SECTION AF-AF
B4-7
SCALE 3X, 4 PL

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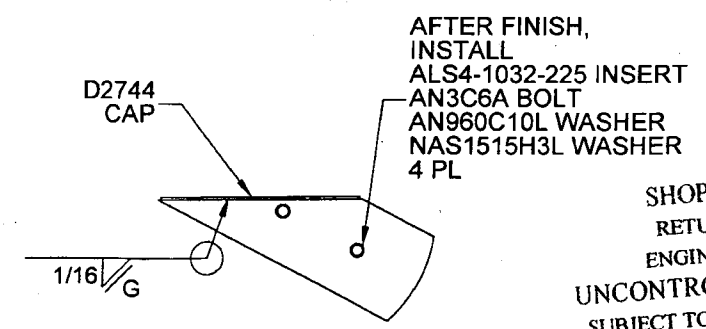
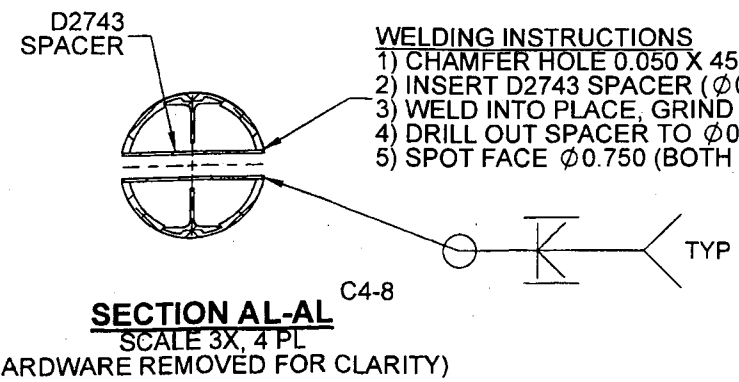
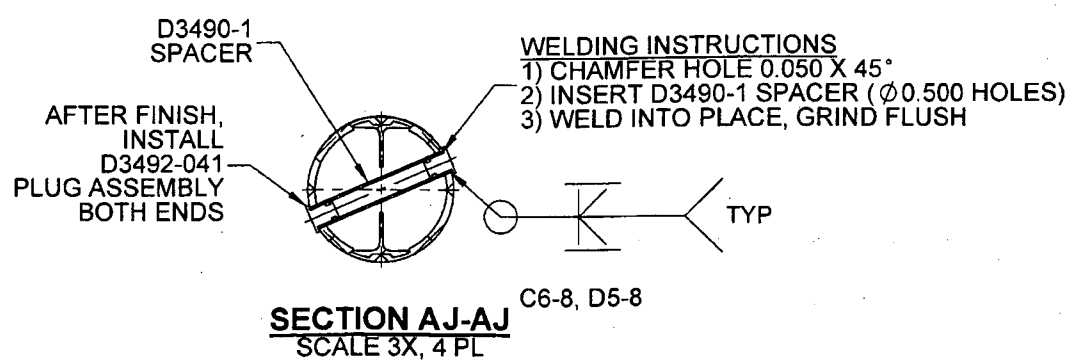
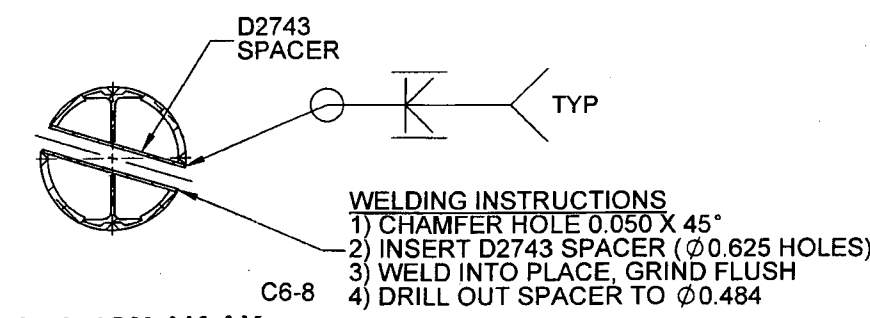
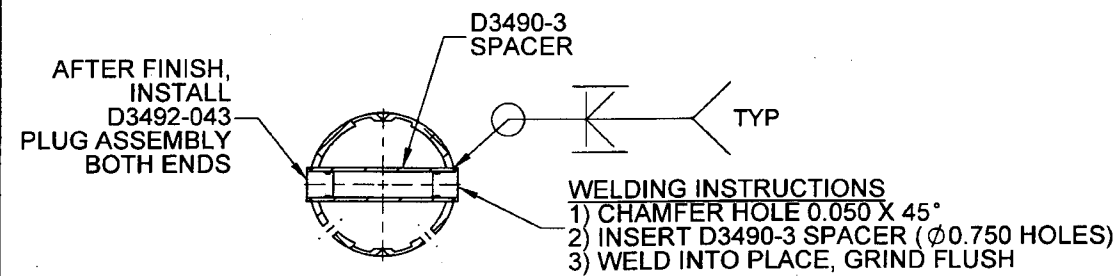
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D2750-041 350 SKIDTUBE ASSEMBLY, LH



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8 7 6 5 4 3 2 1

D

D

C

C

B

B

A

A

A1-9
AM

D2750-2
SKIDTUBE

AFTER FINISH,
ALS4-1032-225 INSERT
34 PL

BLACK ANTI-SKID

AN

AP

AQ

AR

2.0
TYP

1.78 TO
D2739 WEB

D3488-042
BLADE FITTING

AN6C44A BOLT
D2745 BUSHING
D3631-1 WASHER
SKIDTUBE, REF
D3631-1 WASHER
D2745 BUSHING
MS21043-6 NUT
4 PL
(INSTALL NUT ON THIS SIDE)

REFER TO
SECTION AP-AP

A7-9

BOND D2739 WEB INTO D2750-2 OUTER TUBE
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE
PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.

D3794-1
GASKET

D3793-1
WEARSHOE

AN3C5A BOLT
AN960C10L WASHER
34 PL

D3537-1
WEARPAD

D3791-1
WEARPLATE

D3536-25
GASKET

D3535-25
WEARSHOE

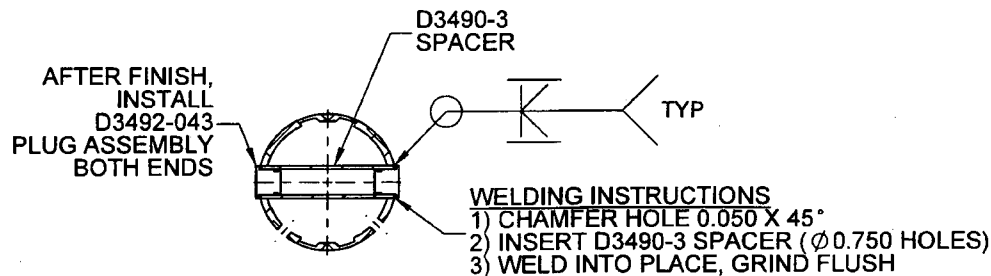
D3537-1
WEARPAD

D3794-3
GASKET

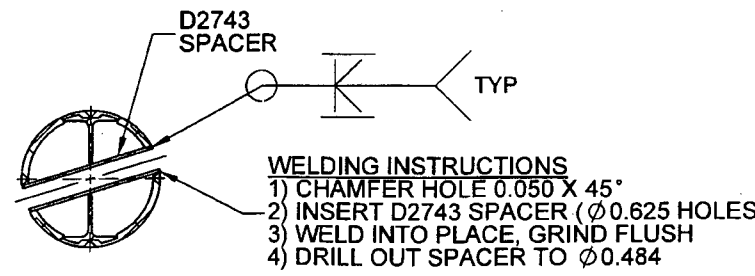
D3793-3
WEARSHOE

AN8C35A BOLT
D3793-3 WEARSHOE, REF
D3794-3 GASKET, REF
SKIDTUBE, REF
D3488-042 BLADE FITTING, REF
SKIDTUBE, REF
D3794-3 GASKET, REF
D3793-3 WEARSHOE, REF
AN960C816L WASHER
MS21083C8 NUT
(INSTALL NUT ON THIS SIDE)

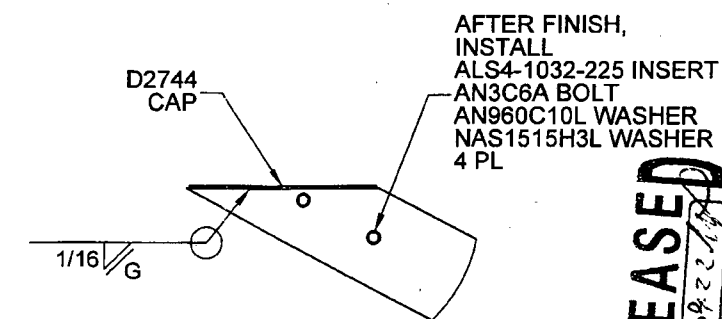
D2750-042 350 SKIDTUBE ASSEMBLY, RH



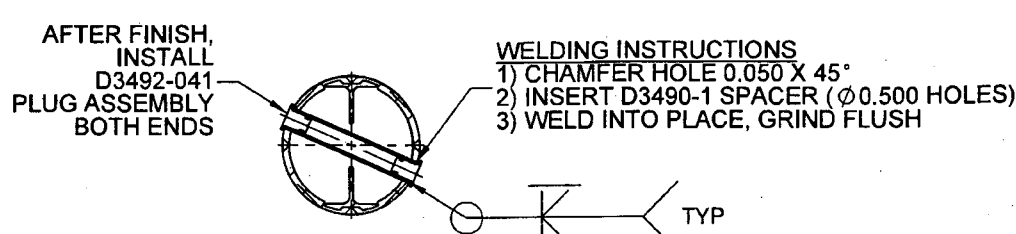
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SCALE 3X, 4 PL



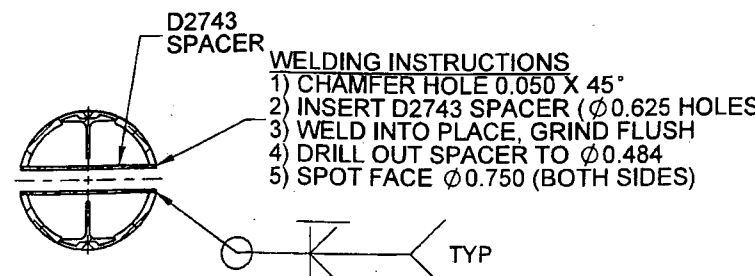
SECTION AQ-AQ
SCALE 3X, 4 PL



DETAIL AM
SCALE 2X



SECTION AP-AP
SCALE 3X, 4 PL



SECTION AR-AR
SCALE 3X, 4 PL
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